

Date: Tuesday, 10/02/2009 11:09:18 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE
 Job Number : 45673
 Estimate Number : 13569
 P.O. Number :
 This Issue : 10/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38141
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3814 REV A
 Previous Run : 42054 Drawing Revision : A
 Written By : Due Date : 28/02/2009 Qty: 2 Um: Each
 Checked & Approved By : JLD 09-02-10
 Comment : Est Rev:A New Issue 08-09-03 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X04500 6061T6 Bar 2.00 x 4.500



Comment: Qty.: 0.6300 ft(s)/Unit Total : 3.7800 ft(s)

6061-T6 Bar 4.500" x 2.00"

BATCH: M169425

DJP 09/02/11

(8)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 7.100 " long

DJP 09/02/11

(8)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA780 Rev: AA & Dwg D3814 Rev: A

Folio FA781

2-Deburr per dwg D3814

3-Finish tapping hole to final depth as per Dwg D3814

J.F. /

DJP 09/02/11

(8)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. /

DJP 09/02/11

(8)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JP 09/02/11 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 11:09:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 45673

Part Number: D38141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-17 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11109996

START TIME:

2:09pm

OVEN TEMPERATURE:

326°F

FINISH TIME:

2:30pm

9/2 09-02-18

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/18

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10/4/18 (8)

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

09/02/2018

Job Completion



MF 09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45673
Description: HINGE		Part Number: D 3814-1
Inspection Dwg: 3814 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00"	±.030"	0.999"	✓			
0.500"	±.030"	.499"	✓			
4.00"	±.030"	3.998"	✓			
0.31"	±.030"	.314"	✓			
0.50"	±.030"	.501"	✓			
Ø 0.257"	±.005	Ø .259"	✓			
4.51"	±.030"	4.510"	✓			
4.82"	±.030"	4.820"	✓			
R0.50"	±.030"	R0.500"	✓			
R0.13"	±.030"	R0.130"	✓			
2.41"	±.030"	2.410"	✓			
.28"	±.030"	.283"	✓			
2.12"	±.030"	2.120"	✓			
10" x 45°	±.030"	100"	✓			
141°	± 1/2°	141°	✓			
Ø .189"	±.005	Ø .190"	✓			
1.88"	±.030"	1.894"	✓			
.75"	±.030"	.750"	✓			
.75"	±.030"	.750"	✓			
1.25"	±.030"	1.251"	✓			
1.25"	±.030"	1.251"	✓			

Measured by: J.F.	Audited by: JF	Prototype Approval:	N/A
Date: 09/02/13	Date: 09/02/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

C

B

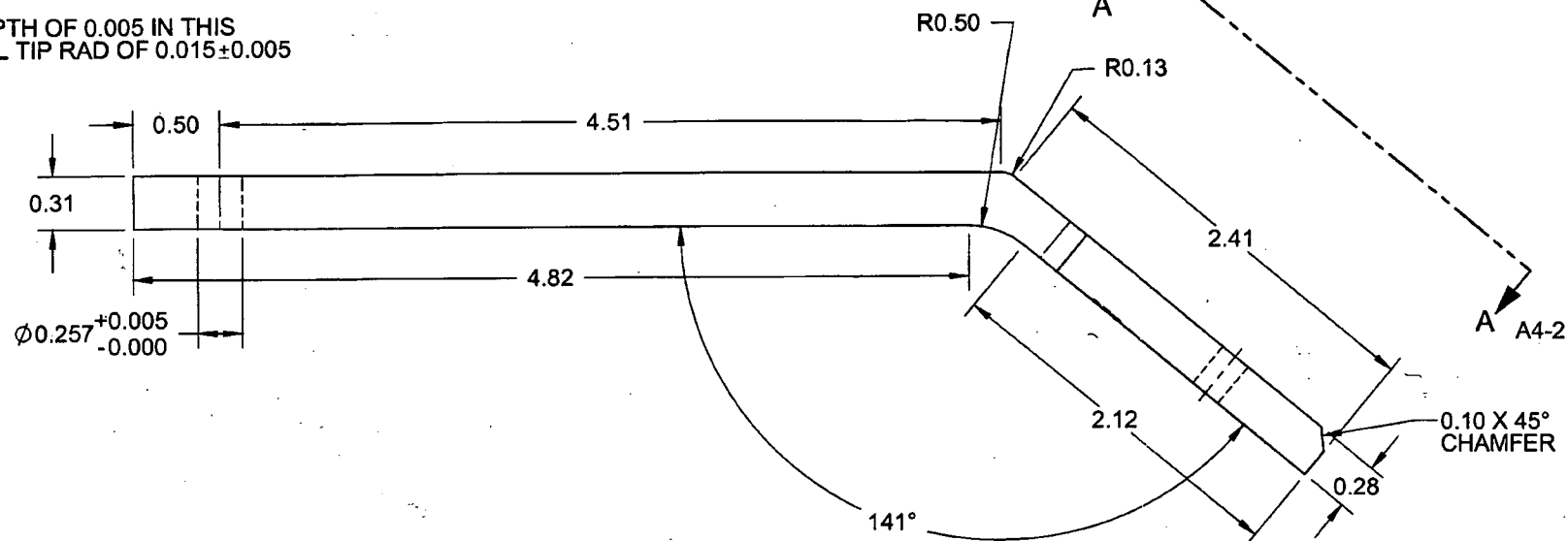
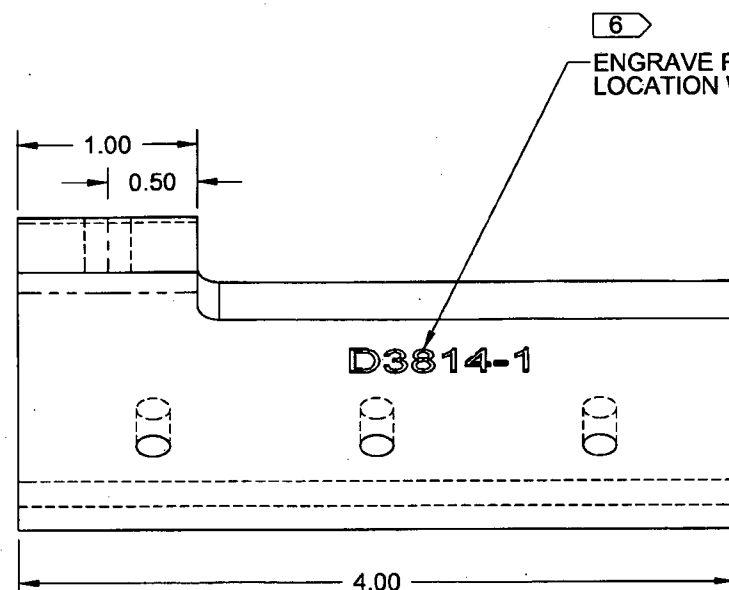
A

D

C

B

A



D3814-1 HINGE, UPPER AIRFRAME

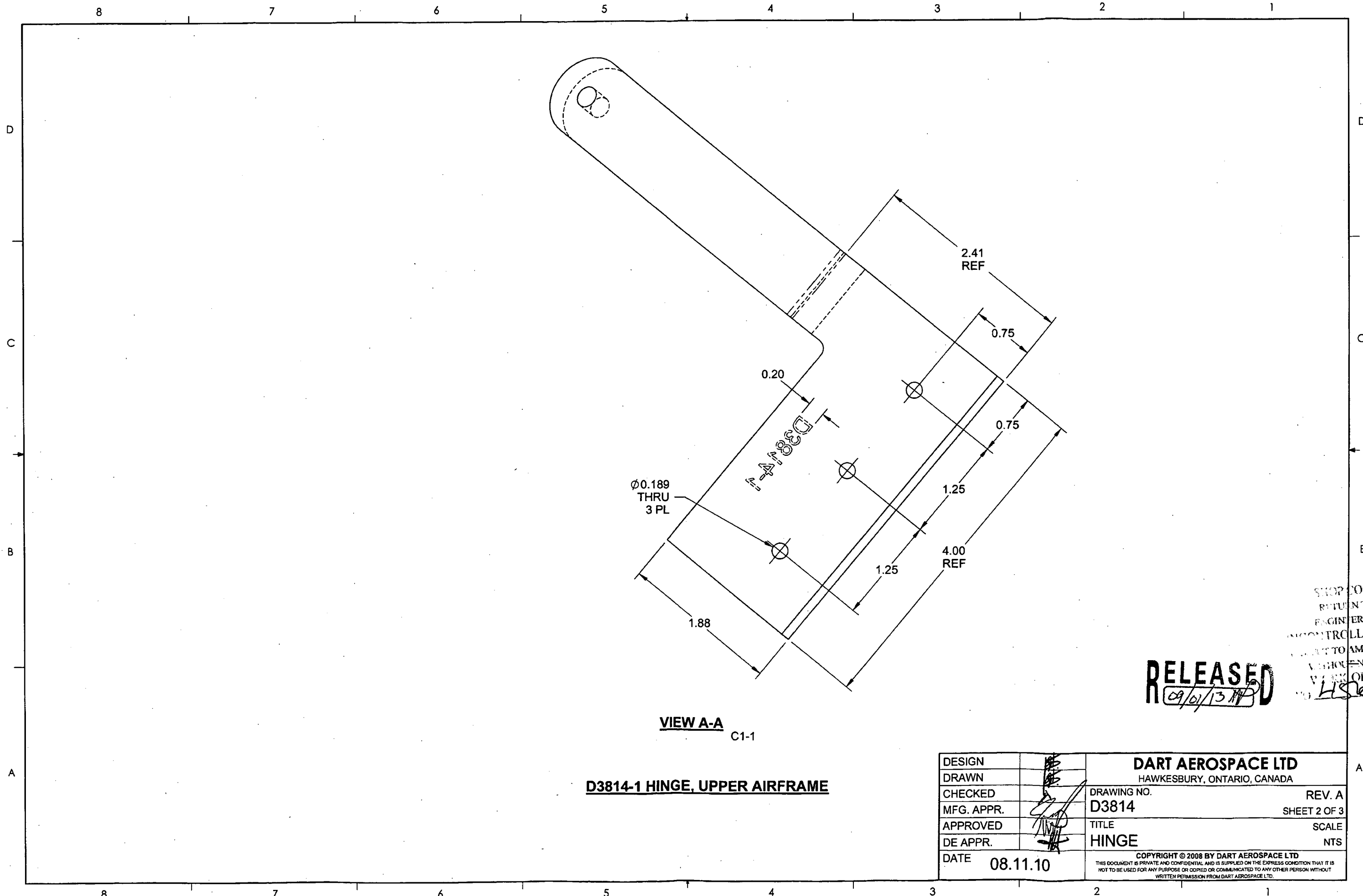
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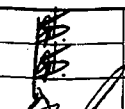
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.36 lbs

A	NEW ISSUE	BY	08.11.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.10		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3814 REV. A SHEET 1 OF 3			
TITLE HINGE SCALE NTS			
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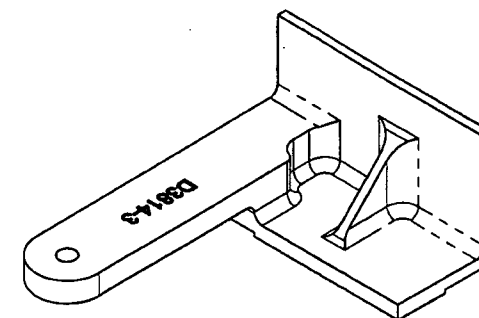
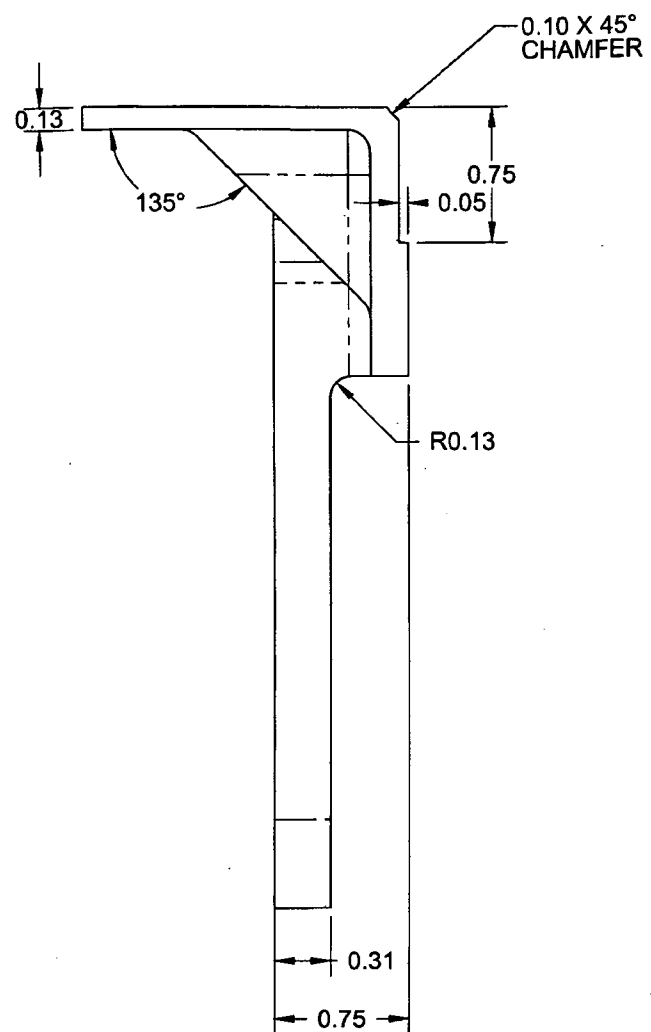
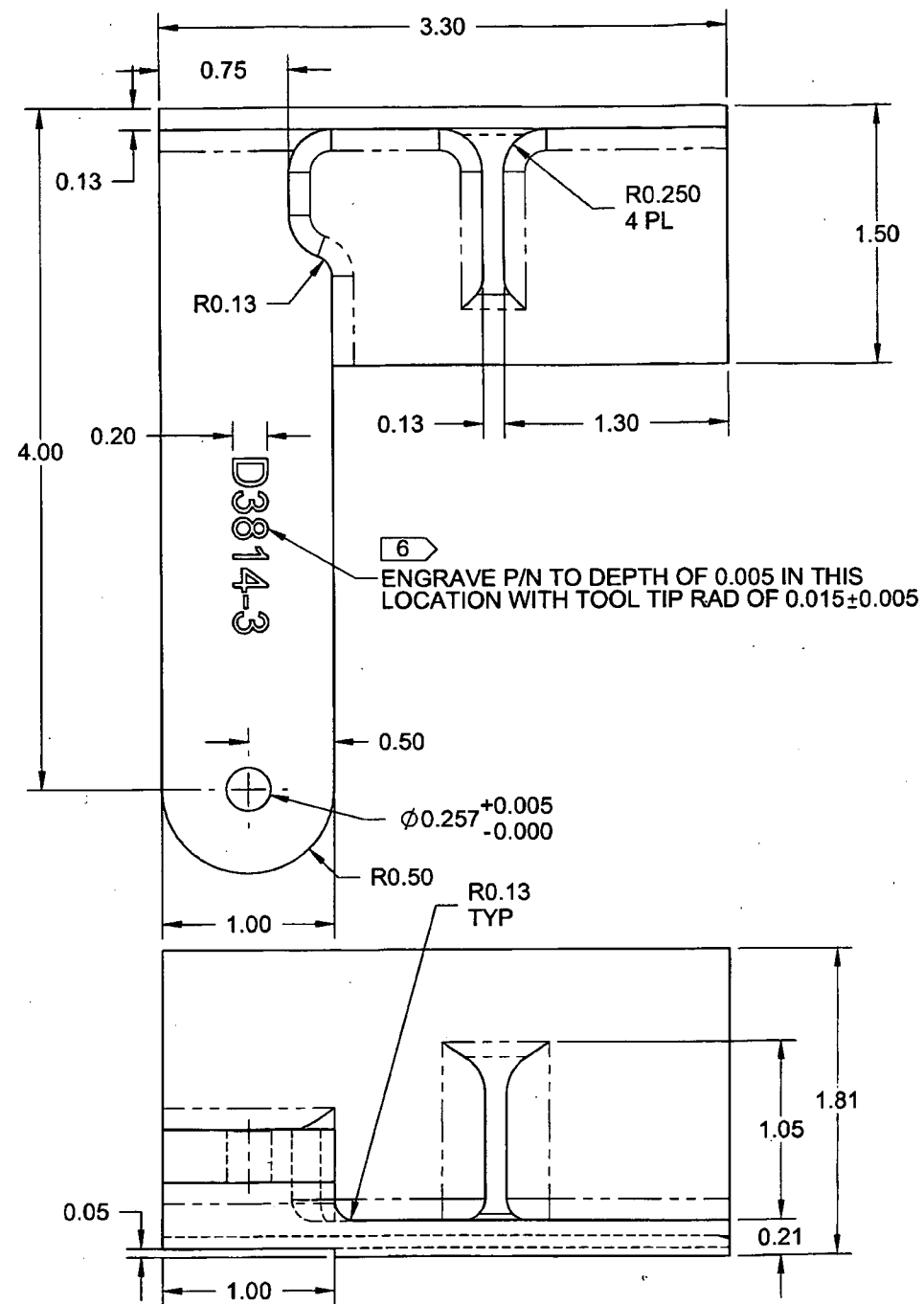


D3814-1 HINGE, UPPER AIRFRAME

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MFG. APPR.		D3814	SHEET 2 OF 3
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D3814-3 HINGE, LOWER AIRFRAME

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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
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